GENERAL NOTES:

THIS DRAWING SHOWS THE STRUCTURAL ARRANGMENT, DETAILS AND MATERIALS FOR THE CONSTRUCTION OF AN ALUMINUM MAIN MAST TO REPLACE THE EXISTING STEEL MAST.

1. EQUIPMENT MOUNTED ON THE EXISTING MAST IS TO BE REMOVED AND DISPOSED OF OR STORED PER DIRECTION OF THE NOAA REPRESENTATIVE. SMALL ANTENNAS TO BE MOUNTED IN ACCORDANCE WITH REFERENCE 1 TO THE SATIFACTION OF THE NOAA REPRESENTATIVE. A

2. ALL NEW PIPE SECTIONS IN THIS PLAN ARE SCHEDULE 40.

3. ALL WELDING TO BE IN ACCORDANCE WITH ABS RULES FOR ALUMINUM VESSELS, 1975, (WITH ALL UPDATES TO 2006) EXCEPT WHERE NOTED OTHERWISE.

4. ALL JOINT CUTTING, PREPARATION AND CLEANING TO BE STRICTLY CARRIED OUT AS FOLLOWS:

   A. ALL CUTTING AND PREPARATION OF EDGES TO BE WELDED TO BE MADE WITH A CLEAN COARSE-TOOTH SAW OR CUTTER OR MANUALLY WITH A CLEAN COARSE FILE. DO NOT GRIND WITH CORUNDUM OR RESIN WHEELS. DO NOT CARBON ARC. A

   B. CUTTING IS TO BE CARRIED OUT WITH APPROPRIATE FEED RATES. EXCESSIVE HEATING OF THE CUT EDGE IS TO BE PREVENTED. A

   C. NICKS, GOUGES, OR OTHER CRACK-LIKE DEFECTS ARE NOT PERMITTED.

   D. EDGES TO BE WELDED AND ADJACENT SURFACES ARE TO BE DEGREASED WITH A NON-CHLORINATED SOLVENT. AFTER DEGREASING, THE EDGES AND ADJACENT SURFACES EQUAL TO THE HAZ MUST BE BRUSHED WITH A CLEAN STAINLESS STEEL ROTARY OR HAND WIRE BRUSH TO REMOVE THE OXIDE LAYER. BRUSH OPERATOR MUST WEAR CLEAN RUBBER GLOVES. WELDING MUST NOT TAKE PLACE ON A BRUSHED JOINT THAT IS OLDER THAN 12 HOURS. JUST PRIOR TO WELDING, AN OXY-ACETYLENE TORCH SHOULD BE USED TO PREHEAT THE JOINT ABOVE THE DEW POINT BUT NO MORE THAN 40 DEGREES CENTIGRADE. A

   E. CLEARANCE BETWEEN WORKPIECES TO BE JOINED SHALL MEET ABS REQUIREMENTS PER REFERENCE (2) OR SHALL BE LESS THAN ONE QUARTER THE THICKNESS OF THE SMALLER MEMBER BEING JOINED.

5. MIG AND TIG WELDING ARE PERMITTED.

6. SOOT DEPOSITS ON THE WORKPIECES LEFT BY THE WELDING ARE TO BE BRUSHED OFF WITH A STAINLESS STEEL WIRE BRUSH.

7. THE MAST IS TO BE BUILT WITH THE OVERALL HEIGHTS AND PLATFORM DIMENSIONS AS SHOWN ON THIS PLAN. THE SPACING BETWEEN THE MAIN LEGS WHERE THEY JOIN THE DECK IS TO BE CONFIRMED BY SURVEYING THE EXISTING MAST.

8. THE EXISTING STEEL MAST IS TO BE ROUGH-CROPPED AT A HEIGHT OF APPROXIMATELY 30" ABOVE THE DECK (THE UPPER PORTION OF THE 02 DECK, AFT OF THE 12" STEP).

9. AFTER SHOP FABRICATION OF THE MAST, THE EXISTING LEGS ARE TO BE EITHER CROPPED BACK TO 24" OR CROPPED TO THE DECK, AS SHOWN ON THIS PLAN. IN THE CASE OF MISALIGNMENT OF THE FORWARD LEGS AND THE EXISTING LEG STUBS, THE STUBS ARE TO BE REMOVED DOWN TO DECK LEVEL AND REPLACED WITH EQUIVALENT TO EXISTING SCANTLINGS. SHEET 7 SHOWS THE EXISTING SCANTLINGS FOR REFERENCE.

10. BOLTING OF THE MAST CONNECTION FLANGES:

    HOLES IN FLANGES ARE TO BE FITTED TO THE BOLTS TO A LIGHT INTERFERENCE FIT.

    THREADS AND FAYING SURFACES OF NUTS BOLTS AND WASHERS TO BE COATED WITH A LOC-TITE MEDIUM STRENGTH THREAD SEALANT BEFORE ASSEMBLY.

    NUTS ARE TO BE TORQUED TO 5,000 INCH-LBS, NOT INCLUDING ANY PREVAILING TORQUE CAUSED BY THREAD FRICTION.

11. WIREWAYS ARE TO BE INSTALLED IN ACCORDANCE WITH REFERENCE (1). ROUTING OF THE WIREWAYS TO BE TO THE SATISFACTION OF THE NOAA REPRESENTATIVE.

12. SURFACE PREPARATION AND COATING TO BE IN ACCORDANCE WTH REFERENCE (1).

13. ALL FIBERGRATE DECKING TO BE MOUNTED IN ACCORDANCE WITH MANUFACTURER'S RECOMMENDATIONS AND WITH STAINLESS STEEL HARDWARE (FIBERGRATE TYPE M HOLD DOWN CLIPS OR AS RECOMMENDED BY MANUFACTURER).

14, QUANTITIES IN LIST OF MATERIALS ARE APPROXIMATE. CONTRACTOR SHALL DETERMINE ACTUAL QUANTITIES.

DESIGN CRITERIA:

A. 90 KNOT WIND IN ANY DIRECTION WITH CD=1
B. ROLL TO +/-45°
C. PERIOD OF ROLL 11 SEC
D. PITCH +/- 7.1°
E. PERIOD OF PITCH 4.4 SEC
F. HEAVE ACCELERATION: $^{44}/_{100}$ ACCELERATION OF GRAVITY

ON TOP OF THE LOADS DEVELOPED FROM THE ABOVE CRITERIA,

G. SAFETY FACTOR=2.5 APPLIED ON AS-WELDED YIELD STRENGTH.
H. FEM OVERALL VIBRATION ANALYSIS
I. INDIVIDUAL TUBES DESIGNED TO HAVE FREQUENCY ABOVE 24 HZ.

ROLL, PITCH, HEAVE WERE ADDED IN PHASE FOR "WORST CASE," WITH HEAVE ADDED VECTORALLY TO VESSEL AT MAXIMUM PITCH/HEAVE ANGLE.

WIND WAS ADDED TO DYNAMIC LOAD WITHOUT REDUCTION OF EFFECTIVE AREA DUE TO HEEL.
HORIZONTAL PLATFORM AREA WAS ASSUMED SOLID AND THE PROJECTED AREA AT 45° WAS USED.
ALL PIPES ASSUMED 100% EXPOSED TO WIND.

LIST OF MATERIALS

PC NO	QTY	DESCRIPTION	MATERIAL	MATERIAL SPEC – GRADE	REMARKS
1	155 LF	8" SCH 40 PIPE	ALUMINUM	ALLOY 5083-H116 OR 6061-T6	LEGS AND DIAGONALS –
2	65 LF	6" SCH 40 PIPE	ALUMINUM	ALLOY 5083-H116 OR 6061-T6	CROSS BAR LIGHT MAST
3	35 LF	4" SCH 40 PIPE	ALUMINUM	ALLOY 6061-T6	ANGLED BRACKETS AT TOP
4	10 LF	3" SCH 40 PIPE	ALUMINUM	ALLOY 6061-T6	CENTER LIGHT MAST
5	35 LF	2-1/2" SCH 40 PIPE	ALUMINUM	ALLOY 6061-T6	SMALL LIGHT MASTS HANDRAIL DIAGONALS
6	90 LF	2" SCH 40 PIPE	ALUMINUM	ALLOY 6061-T6	HANDRAIL STANTIONS LIGHT MAST DIAGONALS
7	100 LF	1-1/2" SCH 40 PIPE	ALUMINUM	ALLOY 6061-T6	TOP HANDRAIL & SPREADER
8	190 LF	1" SCH 40 PIPE	ALUMINUM	ALLOY 6061-T6	BOTTOM HANDRAILS SMALL LIGHT MASTS DIAGS
9	60 SF	1/2" PLATE	ALUMINUM	ALLOY 5083-H116	PLATFORM TOP & LIGHT MAST
10	60 SF	3/8" PLATE	ALUMINUM	ALLOY 5083-H116	UPPER PLATFORM BOTTOM PLATE
11	120 LF	4" X 3/8" FB	ALUMINUM	ALLOY 5083-H116	WALKWAY CIRCLE FLANGE DECK GRATE LANDINGS
12	90 LF	12" X 3/8" FB	ALUMINUM	ALLOY 5083-H116	UPPER PLATFORM WEBS WALKWAY CIRCLE WEB
13	80 LF	8" X 4" X .188" RECT TUBE	ALUMINUM	ALLOY 6061-T6	UPPER PLATFORM OVERHANG LOWER PLATFORM HORIZ
14	50 LF	3" X 1.5" X .188" RECT TUBE	ALUMINUM	ALLOY 6061-T6	PLATFORM GRATING SUPPORT
15	6 SF	1.5" PLATE	ALUMINUM	ALLOY 5083-H116	CONNECTION FLANGES
16	6 SF	1.5" PLATE	MILD STEEL	ABS GRADE D	CONNECTION FLANGE BRACKETS
17	10 SF	3/8" PLATE	MILD STEEL	ASTM A-36	CONNECTION BRACKETS
18	1 PC	8" TO 16" SCH 40 BUTT WELD REDUCER	STEEL	EQ TO ASTM A-53 GRB	EXISTING MAST TRANSITION –
19	6 LF	8" SCH 40 PIPE	STEEL	ASTM A-53 GR B	CONNECTION TO DECK LEGS –
20	200 SF	DECK GRATING (FIBERGRATE)	COMPOSITE	RIGIDEX 1-1/2"	DECK GRATING –
21	2 LF	2-1/2" X 3/8" FB	316 ST.ST.	–	LADDER CLIPS
22	6 SF	1/8" PLATE	316 ST.ST	–	FLANGE GASKETS
23	29 LF	LADDER	ALUMINUM	ALLOY 5083-H116	ASTM F840-83 MOD WITH HEAVY RAILS
24	30 PC	1-1/4"-12UNF THREAD CLASS 2A BOLTS	316L	B8M CLASS 2 65 KSI YIELD	FLANGE BOLTS –
25	30 PC	1-1/4" 12UNF CLASS 2B NUTS	316L	B8M CLASS 2 65 KSI YIELD	FLANGE NUTS –
26	60 PC	1-1/4" TYPE B-WIDE WASHERS	STAINLESS STEEL	316L	FLANGE WASHERS –
27	2 PC	1/2" BOLTS	STAINLESS STEEL	316L	LADDER CLIP BOLTS –
28	2 PC	1/2" NUTS	STAINLESS STEEL	316L	LADDER CLIP NUTS –
29	6 PC	1/2" WASHERS	STAINLESS STEEL	316L	LADDER CLIP WASHERS –
30	A/R LF	4" X 2" 1/4" RECT TUBE	ALUMINUM	ALLOY 6061-T6	UPPER PLATFORM OVERHANG LOWER PLATFORM HORIZ
31	1 PC	SEA TEL C-BAND VSAT RADOME & EQUIPT	–	–	GOV'T FURNISHED EQUIP LOWER PLATFORM HORIZ
22	4 PC	2" X 3/8" RINGS	ALLOY 5083-H116	–	HALYARD STAPLES
33	200 LF	1/4" 1X19 SS RIGGING WIRE ROPE	STAINLESS STEEL	–	RIGGING FOR LIGHT MAST
34	7 PC	JAW & JAW TURNBUCKLE FOR PC 33 HANES SUPPLY, INC. #S0108-JJ16	STAINLESS STEEL	–	RIGGING FOR LIGHT MAST
35	7 PC	SWAGELESS FORK TERMINAL FOR PC 33 HANES SUPPLY, INC. #N020-0816	STAINLESS STEEL	–	RIGGING FOR LIGHT MAST
36	7 PC	SWAGELESS EYE TERMINAL FOR PC 33 HANES SUPPLY, INC. #N010-0816	STAINLESS STEEL	–	RIGGING FOR LIGHT MAST
37	28 LF	CLIMBING SAF-T-RAIL	STAINLESS STEEL	316L	FOR LIGHT MAST
38	27 PC	11-1/8" SS CLIMBING STEP A&B INDUSTRIES, P/N 183223	STAINLESS STEEL	316L	FOR LIGHT MAST
39	2 LF	3/4" SS ROD	STAINLESS STEEL	316L	LIGHT MAST BASE
40	3 SF	1/4" PLATE	ALUMINUM	ALLOY 5083-H116	LIGHT MAST SPREADER BRKT

REVISIONS

REV	SHT	ZONE	ITEM	DESCRIPTION	DATE	APPD
A	ALL	ALL	–	ADDED TASK LIGHT/MASTHEAD MAST TO SOLVE LIGHTING ARRANGEMENT ISSUES	09/18/07	–

REFERENCES

NO	TITLE	DRAWING NO
1	NOAA SHIPYARD SPECIFICATION, 2007	–
2	ABS RULES FOR ALUMINUM VESSELS, 1975, WITH UPDATES TO TO06	
3	MAST	171-0000033
4	BOOKLET OF GENERAL PLANS	MC-085-001
5	INSTALL & OP MAN SEA TEL 9797A-22 C-BAND	123213

NATIONAL OCEANIC AND ATMOSPHERIC ADMINISTRATION
OFFICE OF MARINE & AVIATION OPERATIONS

Seaworthy Systems, Inc.
P.O. BOX 993
ESSEX, CT 06426
TEL: (860) 767-9061

CONTRACT # AB133M-05-CQ-1043
TAR-SSI-008

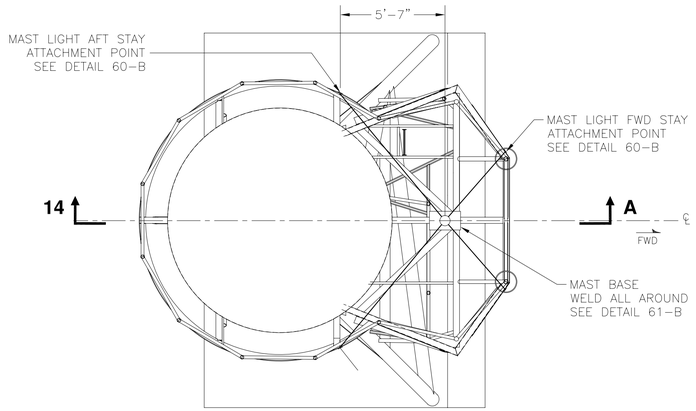
DSGN	10/26/06	WRP
DWN	10/26/06	WRP
CHK	10/26/06	JAH
CHK	10/26/06	WAW
–		NOAA APPROVAL

NOAA SHIP MCARTHUR II

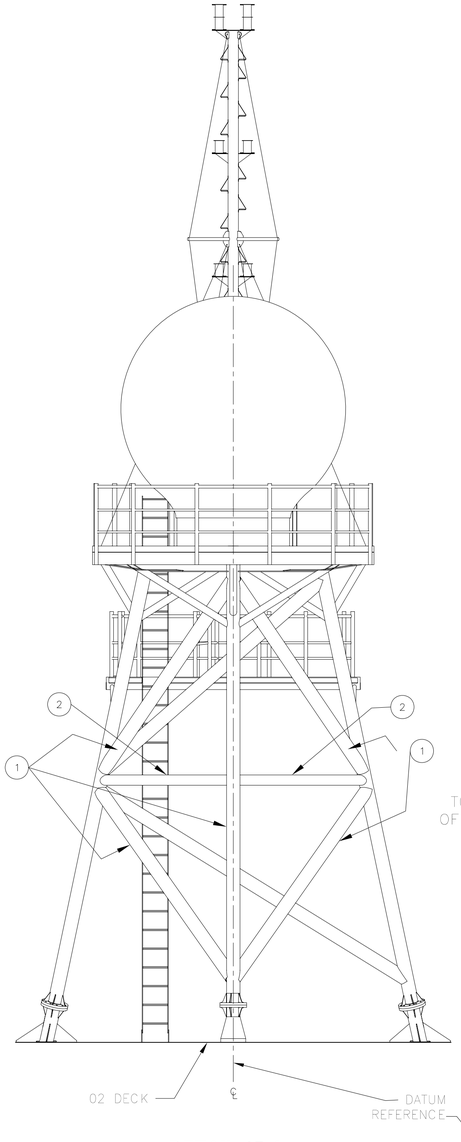
NEW MAINMAST
FOR VSAT RADOME
AND NAVIGATION

SIZE	CAGE CODE	NOAA DRAWING NUMBER	REV
D	0YLJ5	MC-171-001	A

SCALE: AS SHOWN | CAD FILENAME MC-171-001 SHT 1 OF 8

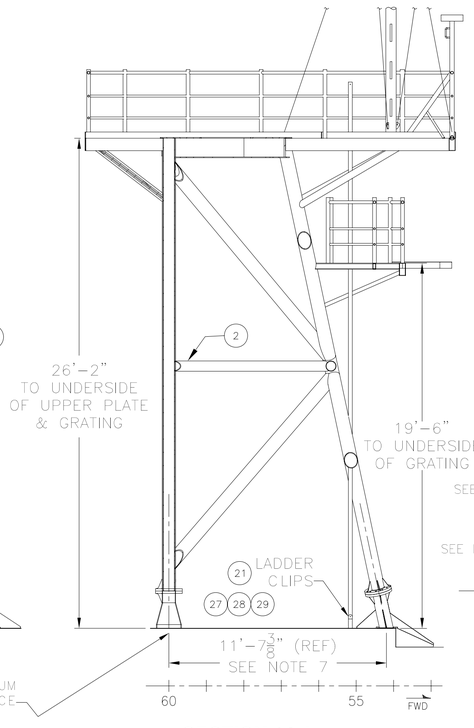


DETAIL 14-D
MAST ASSEMBLY PLAN VIEW
SCALE: 1/4" IN =1 FT

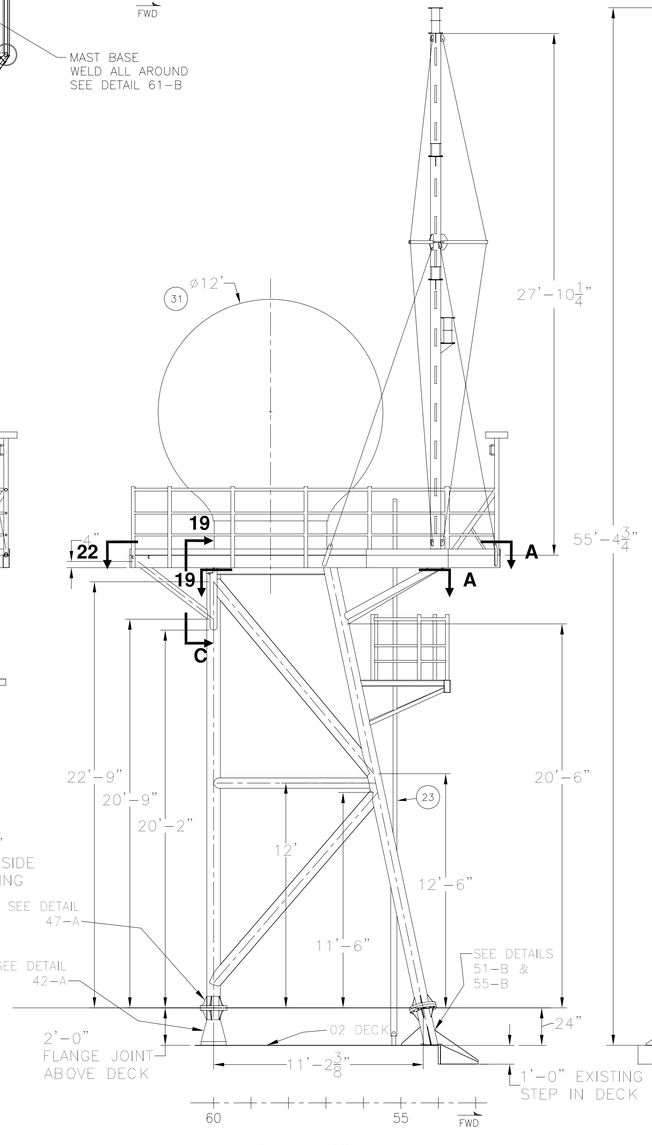


DETAIL 15-A
MAST ASSEMBLY AFT SECTION VIEW (FR 62 LKG FWD)
SCALE: 1/4 IN =1 FT

SEE 39-B FOR SMALL ANTENNA RELOCATION GUIDANCE.

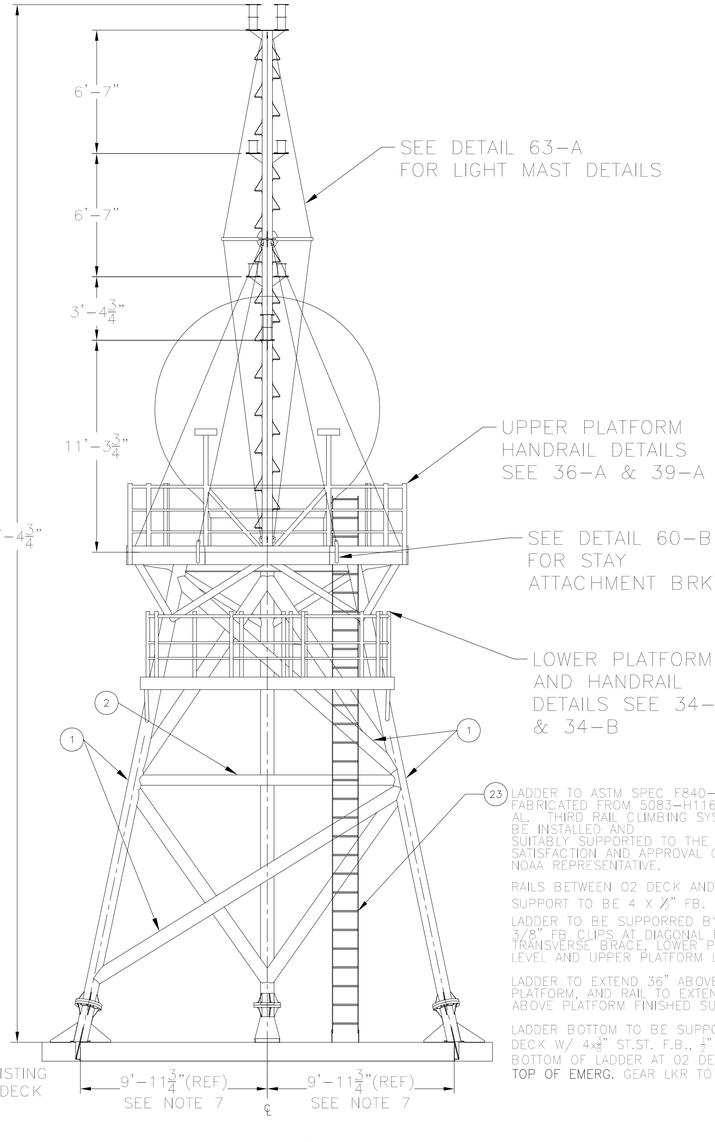


SECTION 14-A
THROUGH CENTERLINE LKG PORT
SCALE: 1/4 IN =1 FT

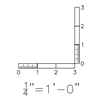


DETAIL 12-A
MAST ASSEMBLY STBD ELEV VIEW
SCALE: 1/4 IN =1 FT

△A LIGHT MAST ADDED TYPICAL THROUGHOUT DRAWING


6'-7"
6'-7"
3'-4¾"
11'-3¾"
55'-4¾"
SEE DETAIL 63-A FOR LIGHT MAST DETAILS
UPPER PLATFORM HANDRAIL DETAILS SEE 36-A & 39-A
SEE DETAIL 60-B FOR STAY ATTACHMENT BRKT
LOWER PLATFORM AND HANDRAIL DETAILS SEE 34-A & 34-B
2
1
1
23 LADDER TO ASTM SPEC F840-83, FABRICATED FROM 5083-H116 AL. THIRD RAIL CLIMBING SYSTEM TO BE INSTALLED AND SUITABLY SUPPORTED TO THE SATISFACTION AND APPROVAL OF NOAA REPRESENTATIVE.
RAILS BETWEEN 02 DECK AND 1ST SUPPORT TO BE 4 X ½" FB.
LADDER TO BE SUPPORRED BY 4" X 3/8" FB CLIPS AT DIAGONAL BRACES, TRANSVERSE BRACE, LOWER PLATFORM LEVEL AND UPPER PLATFORM LEVEL.
LADDER TO EXTEND 36" ABOVE UPPER PLATFORM, AND RAIL TO EXTEND 42" ABOVE PLATFORM FINISHED SURFACE.
LADDER BOTTOM TO BE SUPPORTED AT DECK W/ 4x⅜" ST.ST. F.B., ½" ST.ST. BOLTS BOTTOM OF LADDER AT 02 DECK OR TOP OF EMERG. GEAR LKR TO SUIT NOAA REP.
9'-11¾"(REF) SEE NOTE 7
9'-11¾"(REF) SEE NOTE 7
℄

DETAIL 10-A
MAST ASSEMBLY FWD SECTION VIEW (FR 52 LKG AFT)
SCALE: 1/4 IN =1 FT



¼"=1'-0"

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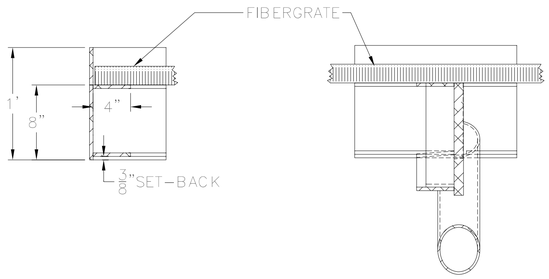
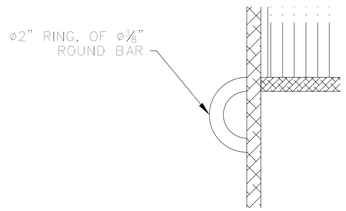
	SCALE: AS SHOWN	CAD FILENAME MC-171-001.dwg	SHT 2 OF 8

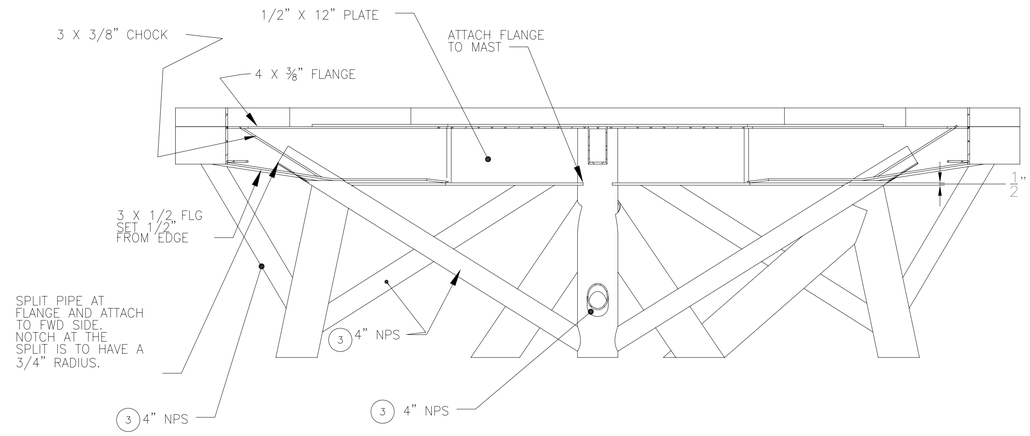


SECTION 23-C
RING FRAME
SCALE: 1-1/2 IN = 1 FT

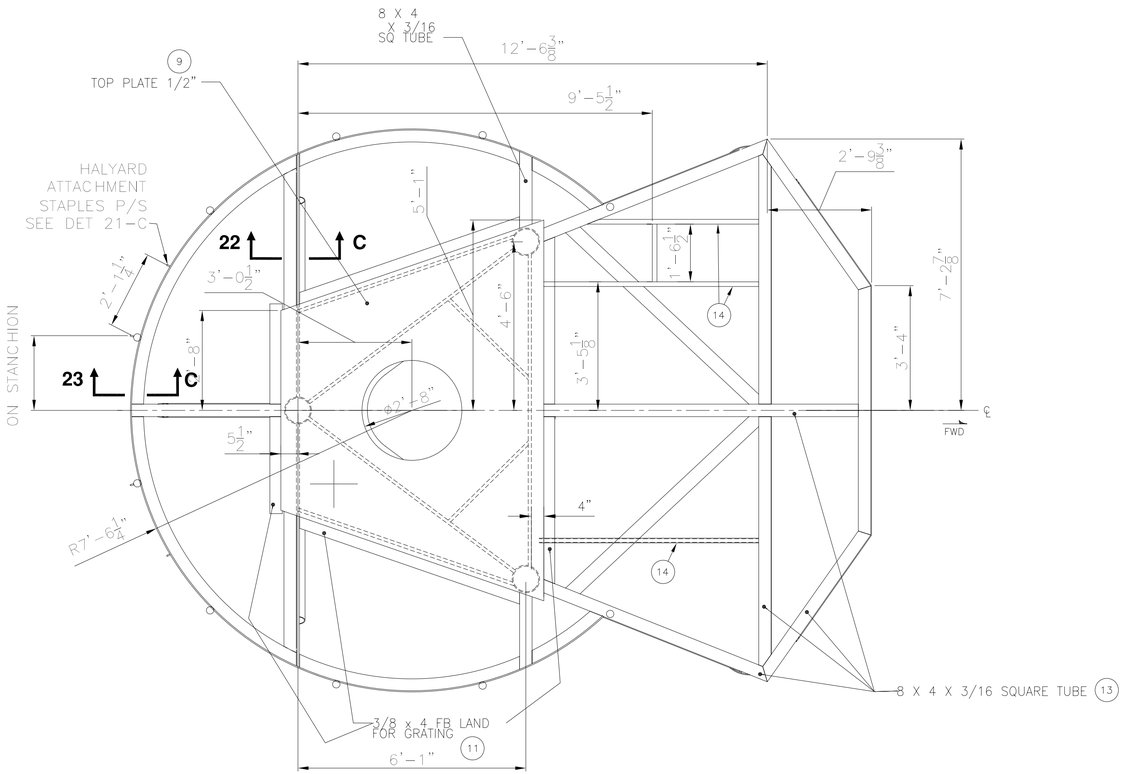
SECTION 22-C
RING FRAME
SCALE: 1-1/2 IN =1 FT



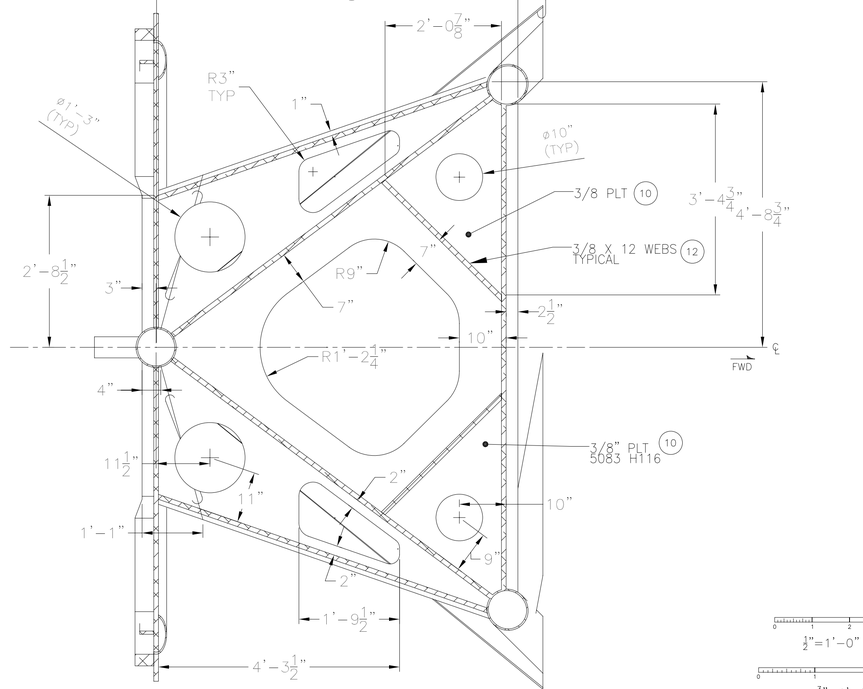
DETAIL 21-C
HALYARD STAPLE
HALF-SCALE

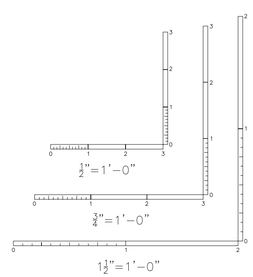

1/2" X 12" PLATE
3 X 3/8" CHOCK
ATTACH FLANGE TO MAST
4 X ⅜" FLANGE
3 X 1/2 FLG SET 1/2" FROM EDGE
SPLIT PIPE AT FLANGE AND ATTACH TO FWD SIDE. NOTCH AT THE SPLIT IS TO HAVE A 3/4" RADIUS.
3 4" NPS
3 4" NPS
3 4" NPS
1/2"

SECTION 19-C
PLATFORM CONNECTION DETAILS
SCALE: 3/4 IN = 1 FT



SECTION 22-A
TOP PLATE AND GRATING SUPPORT DETAILS
SCALE: 1/2 IN = 1 FT





SECTION 19-A
BOTTOM PLATE AND STRUCTURE DETAILS
SCALE: 3/4 IN = 1 FT

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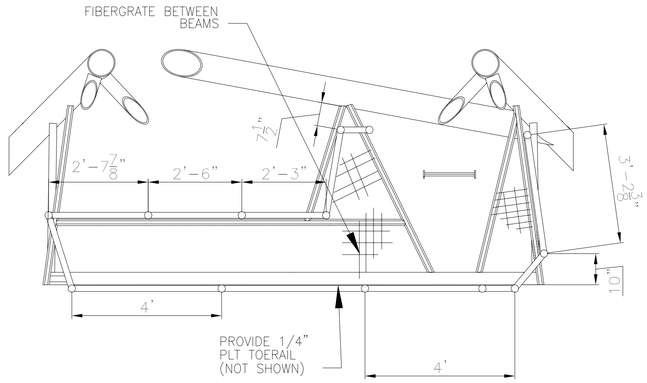
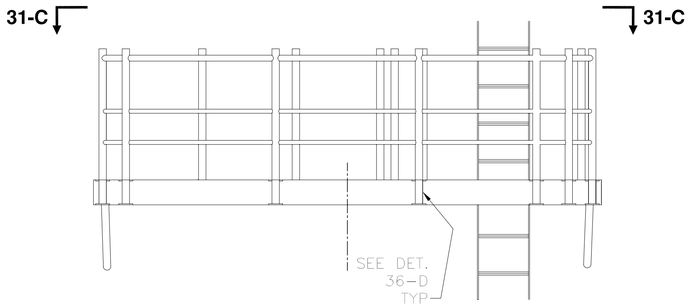
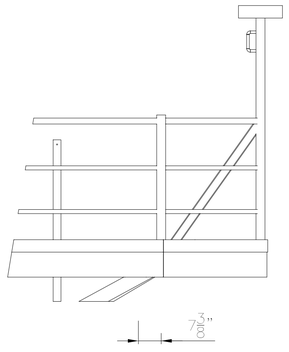
	SCALE: AS SHOWN	CAD FILENAME MC-171-001.dwg		SHT 3 OF 8



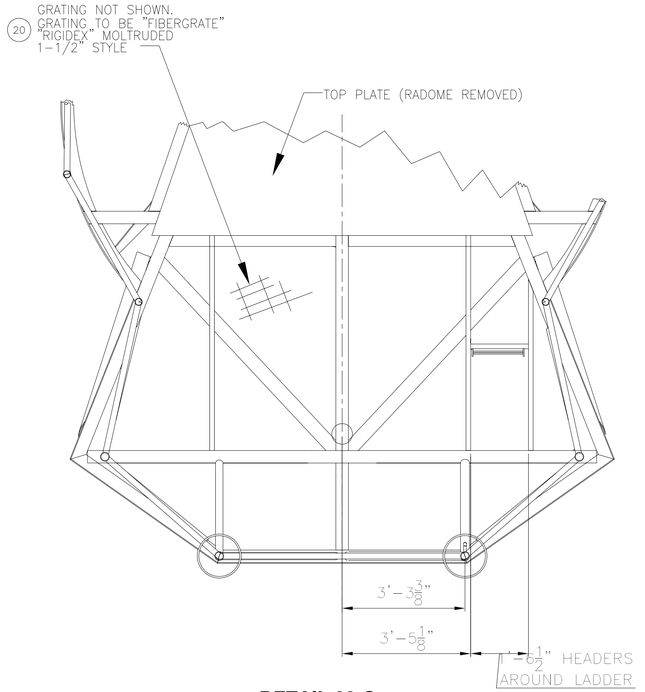
SECTION 31-C
LOWER PLATFORM DETAILS VERSION (B)
SCALE: 1/2 IN = 1 FT



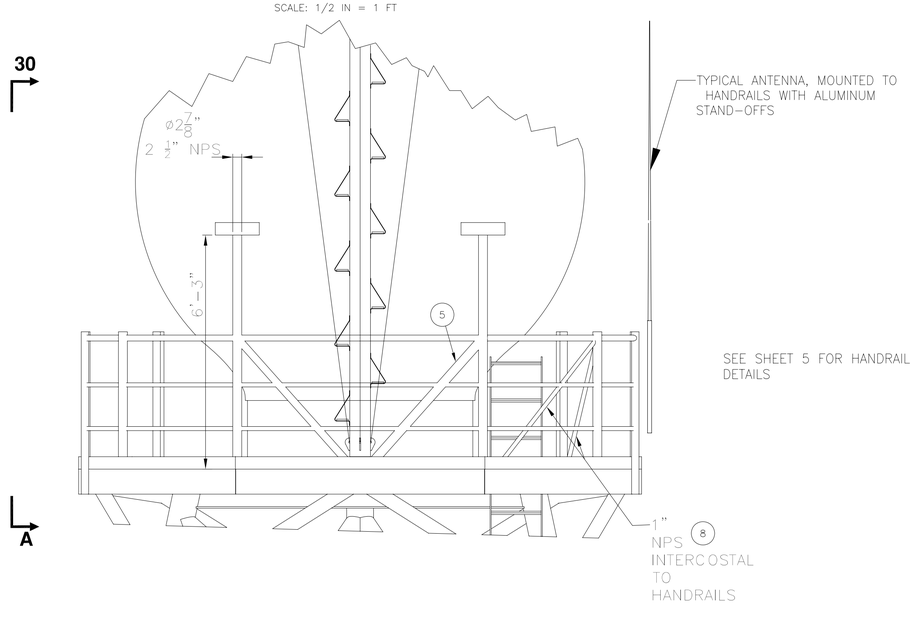
DETAIL 31-B
LWR PLATF HANDRAIL ARRGT VERSION (B)
SCALE: 1/2 IN = 1 FT
SEE 34-A FOR ARRGT VERSION (A)



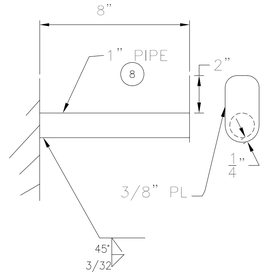
DETAIL 30-A
MAST LIGHT ELEV VIEW LOOKING TO PORT
SCALE: 1/2 IN = 1 FT
HANDRAILS OMITTED



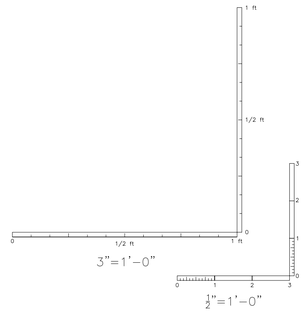
DETAIL 28-C
UPPER PLATFORM PLAN VIEW
SCALE: 1/2 IN = 1 FT



DETAIL 28-A
SECTION VIEW (FWD LKG AFT)
SCALE: 1/2 IN = 1 FT



DETAIL 25-C
CLIMBING RUNGS
SCALE: 3 IN = 1 FT



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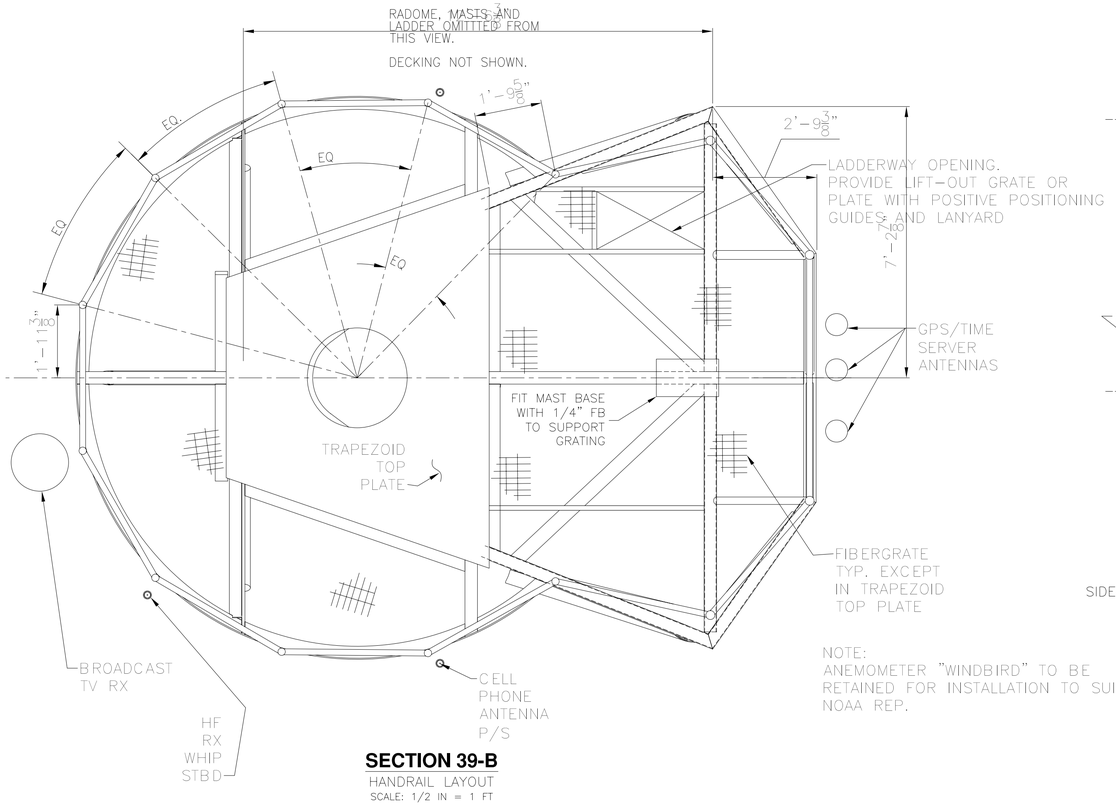
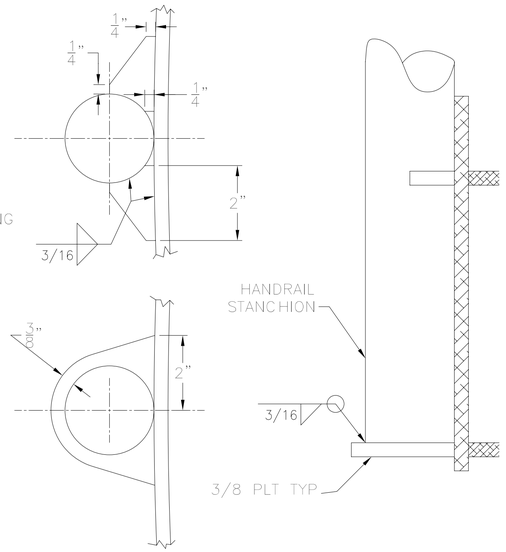
	D	0YLJ5	MC-171-001	A
	SCALE: AS SHOWN		CAD FILENAME MC-171-001.dwg	SHT 4 OF 8

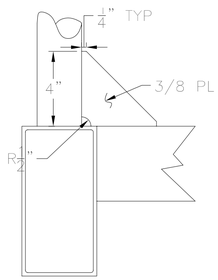


SECTION 39-B
HANDRAIL LAYOUT
SCALE: 1/2 IN = 1 FT

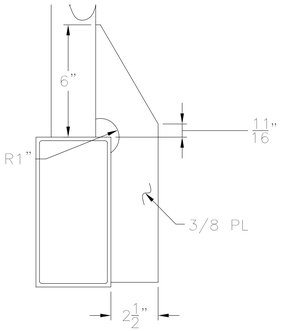
NOTE:
ANEMOMETER "WINDBIRD" TO BE RETAINED FOR INSTALLATION TO SUIT NOAA REP.



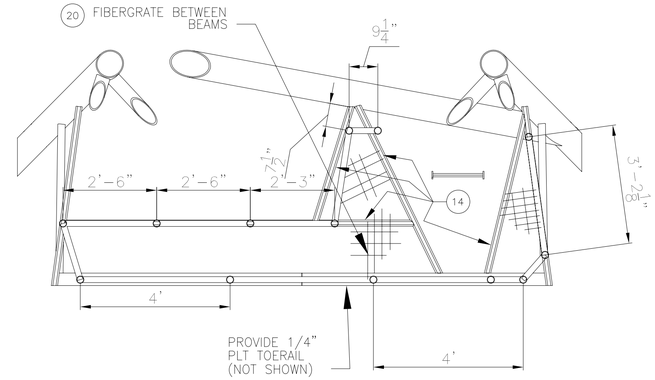
DETAIL 36-C
SIDE-MOUNTED HANDRAIL STANCHION ATTACHMENT
HALF-SCALE



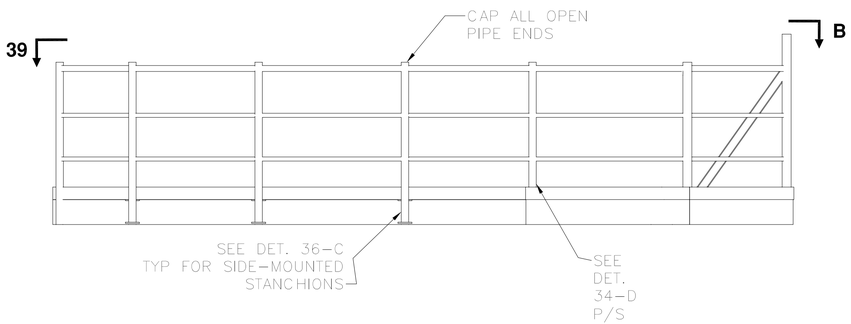
DETAIL 35-D
STANCHION ATTACHMENT
SCALE: 3"=1'-0"



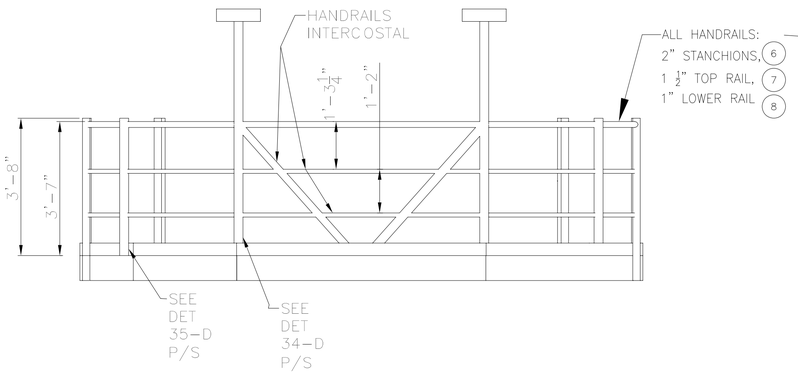
DETAIL 34-D
STANCHION ATTACHMENT
SCALE: 3"=1'-0"



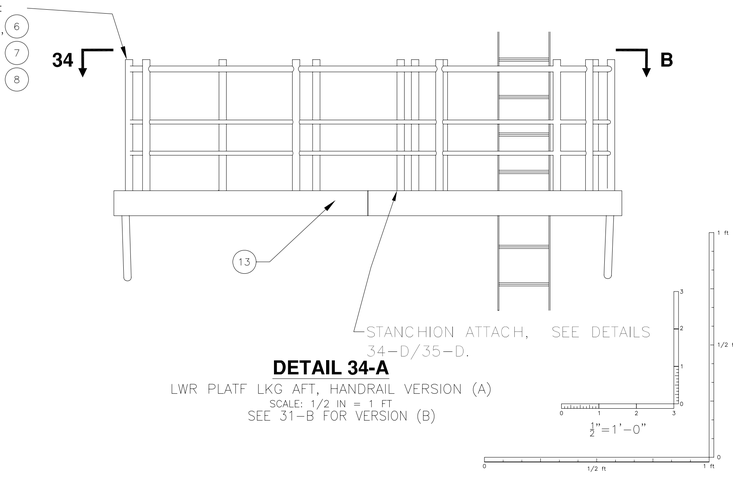
SECTION 34-B
LOWER PLATFORM DETAILS, VERSION (A)
SCALE: 1/2 IN = 1 FT
SEE 31-C FOR VERSION (B)



DETAIL 39-A
HAND RAIL DETAIL ELEV VIEW (STBD LKG PORT)
SCALE: 1/2 IN = 1 FT



DETAIL 36-A
HAND RAIL DETAILS SECTION VIEW (AFT LKG FWD)
SCALE: 1/2 IN = 1 FT



DETAIL 34-A
LWR PLATF LKG AFT, HANDRAIL VERSION (A)
SCALE: 1/2 IN = 1 FT
SEE 31-B FOR VERSION (B)

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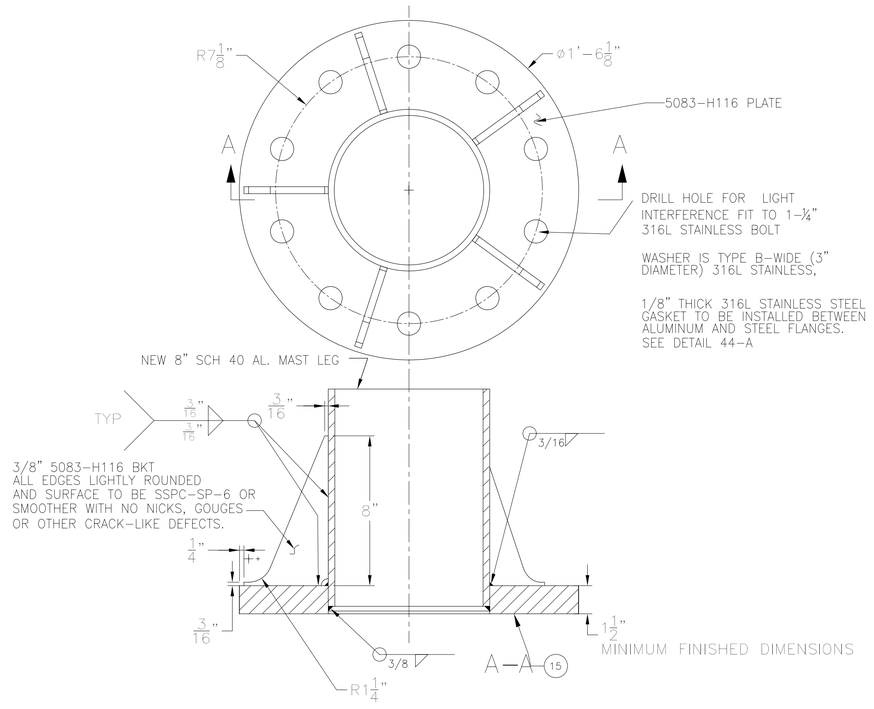
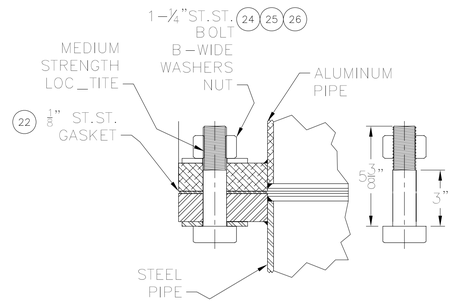
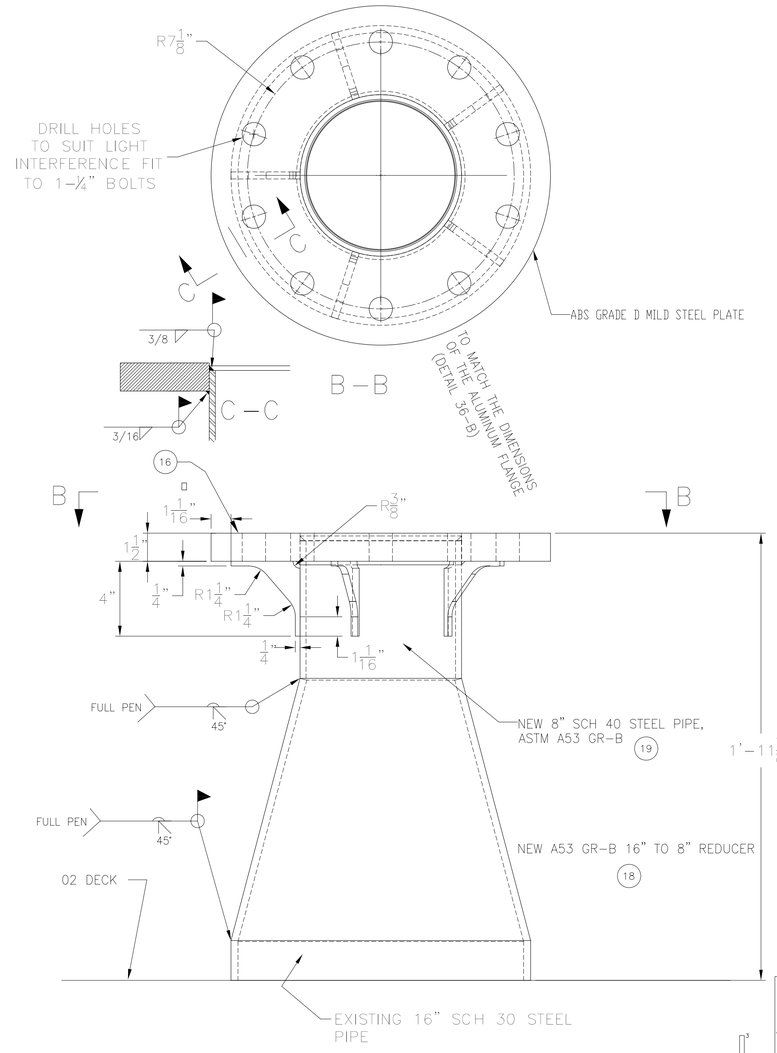
	SCALE: AS SHOWN	CAD FILENAME MC-171-001.dwg	SHT 5 OF 8



DETAIL 47-A
ALUMINUM FLANGE DETAIL
SCALE: 3 IN = 1 FT



DETAIL 44-A
FLANGE BOLT DETAIL
SCALE: 3 IN = 1 FT



DETAIL 42-A
AFT MAST DECK CONNECTION DETAIL
SCALE: 3 IN = 1 FT

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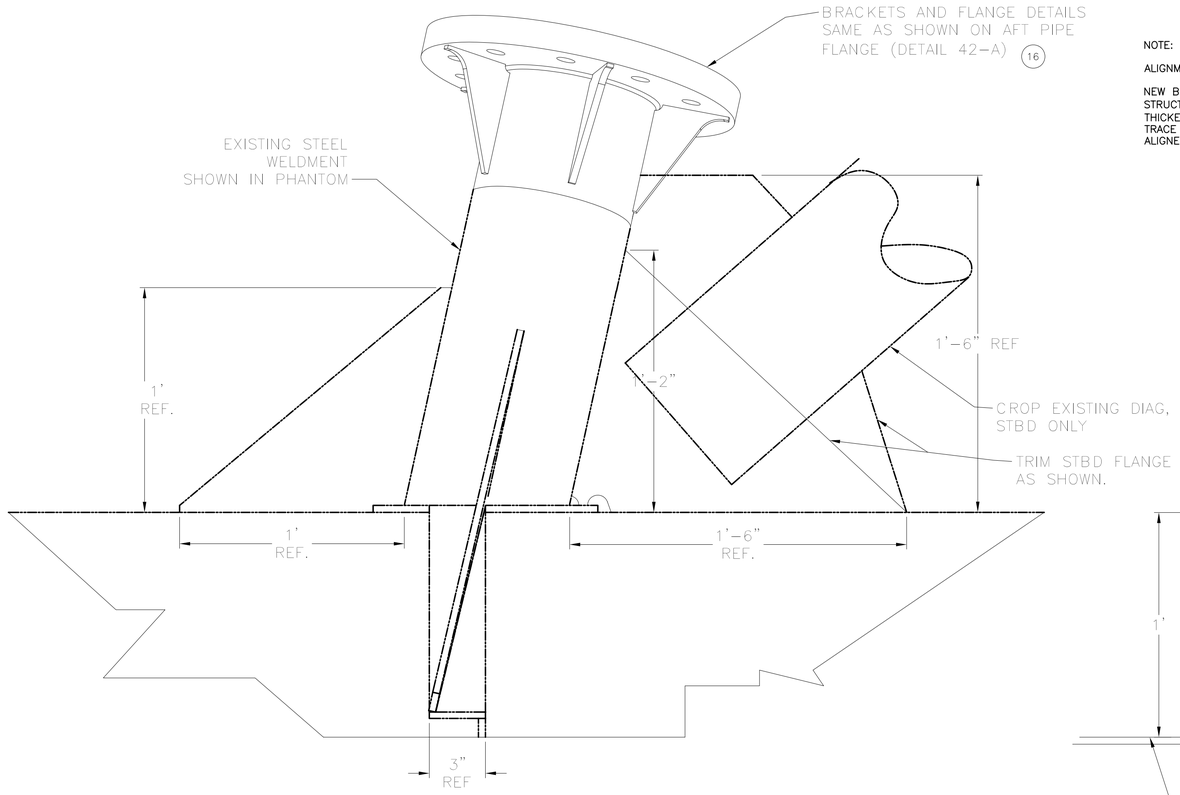
ESSEX, CT 06426
TEL: (860) 767-9061

SIZE	CAGE CODE	NOAA DRAWING NUMBER	REV
D	0YLJ5	MC-171-001	A
SCALE: AS SHOWN		CAD FILENAME MC-171-001.dwg	SHT 6 OF 8


BRACKETS AND FLANGE DETAILS SAME AS SHOWN ON AFT PIPE FLANGE (DETAIL 42-A) (16)
EXISTING STEEL WELDMENT SHOWN IN PHANTOM
1' REF.
1'-2"
1'-6" REF
CROP EXISTING DIAG, STBD ONLY
TRIM STBD FLANGE AS SHOWN.
1' REF.
1'-6" REF.
3" REF

DETAIL 55-B

FWD MAST DECK CONNECTION SECTION VIEW (LKG AFT)

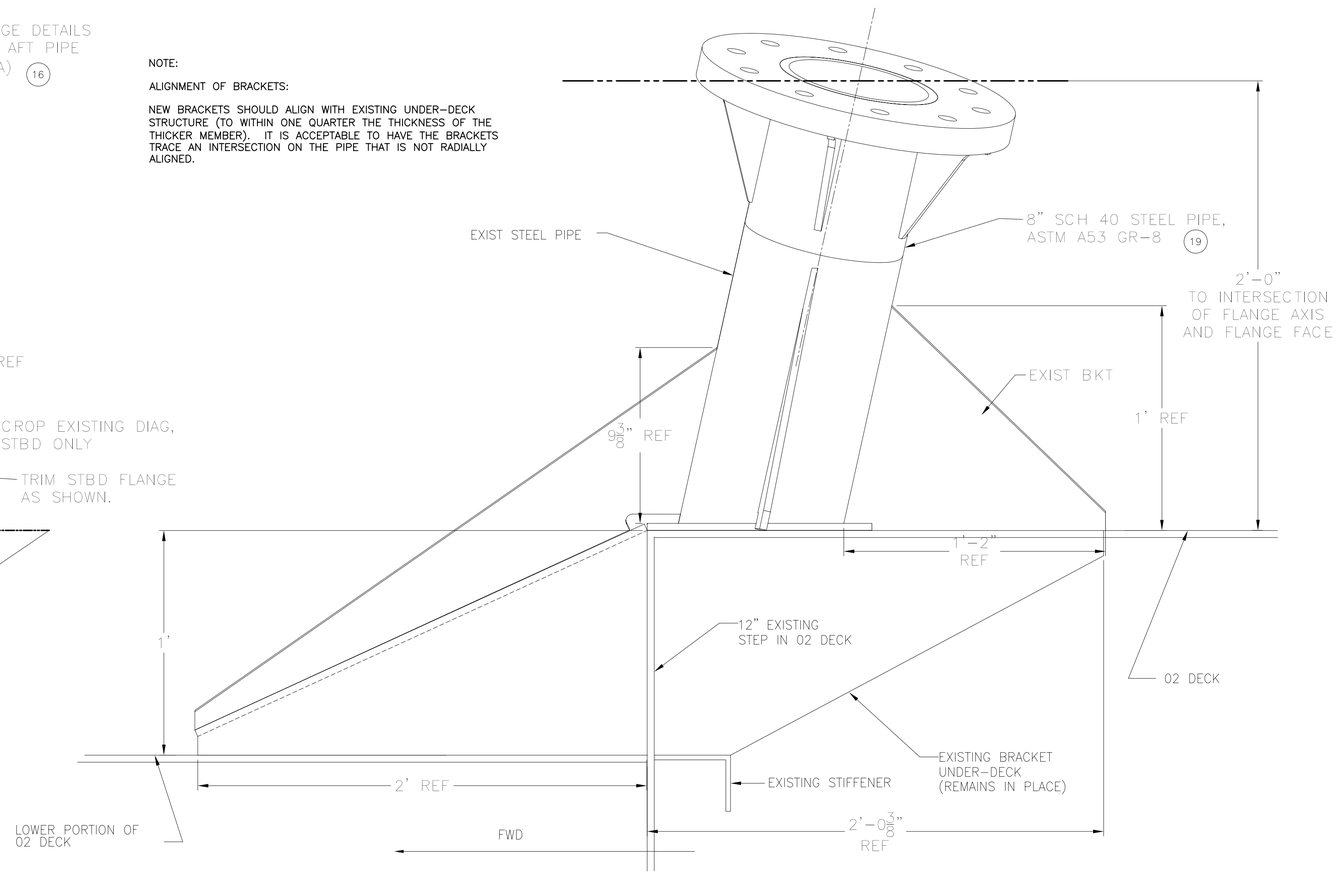
SCALE: 3 IN = 1 FT

PORT SIMILAR TO OPPOSITE HAND

NOTE:

ALIGNMENT OF BRACKETS:

NEW BRACKETS SHOULD ALIGN WITH EXISTING UNDER-DECK STRUCTURE (TO WITHIN ONE QUARTER THE THICKNESS OF THE THICKER MEMBER). IT IS ACCEPTABLE TO HAVE THE BRACKETS TRACE AN INTERSECTION ON THE PIPE THAT IS NOT RADIALLY ALIGNED.



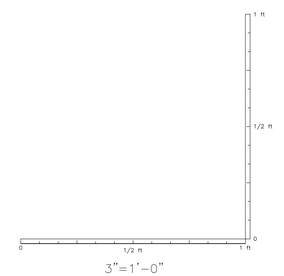
DETAIL 51-B

STBD FWD MAST CONNECTION ELEV VIEW (LKG OUTBD)

(PORT LEG SIM OPPOSITE HAND)

SCALE: 3 IN = 1 FT

PORT SIMILAR TO OPPOSITE HAND



3"=1'-0"

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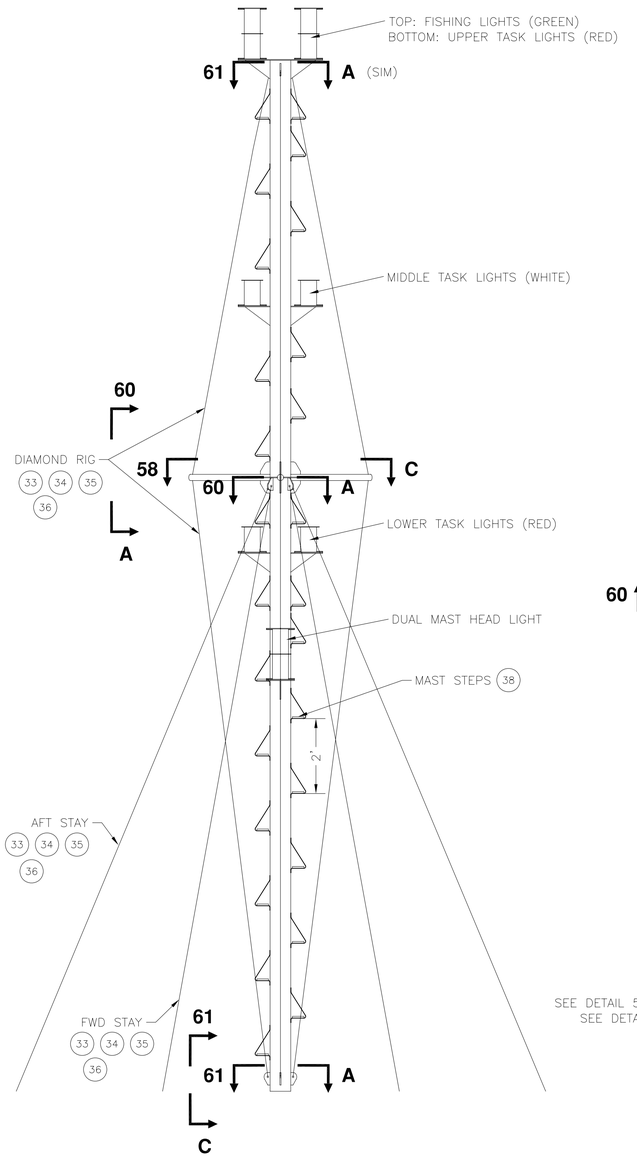
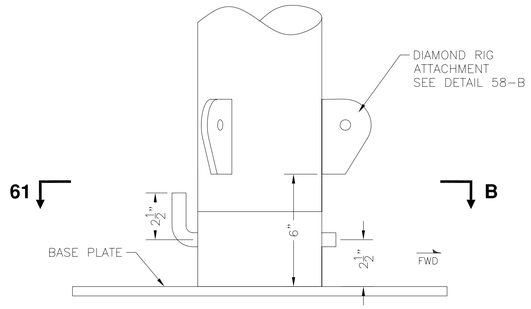
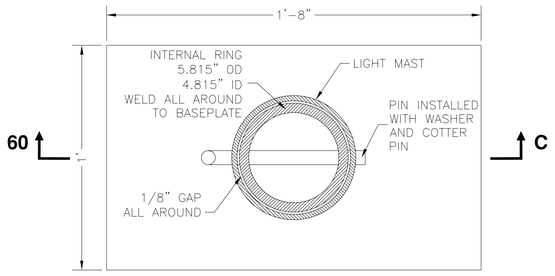
	SCALE: AS SHOWN		CAD FILENAME MC-171-001.dwg	SHT 7 OF 8



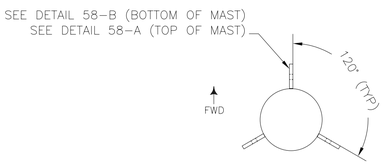
DETAIL 63-A
LIGHT MAST (LKG AFT)
SCALE: 1/2 IN = 1 FT



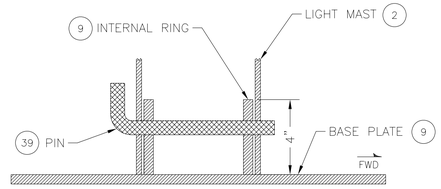
DETAIL 61-C
MAST BASE (LKG TO PORT)
SCALE: 3 IN = 1 FT



DETAIL 61-B
MAST BASE (LKG DOWN)
SCALE: 3 IN = 1 FT

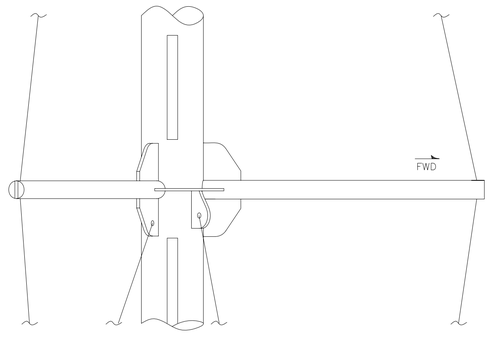


DETAIL 61-A
DIAMOND RIG ATTACHMENT BRACKET ARRGT (BOTTOM OF MAST)
SCALE: 1-1/2 IN = 1 FT

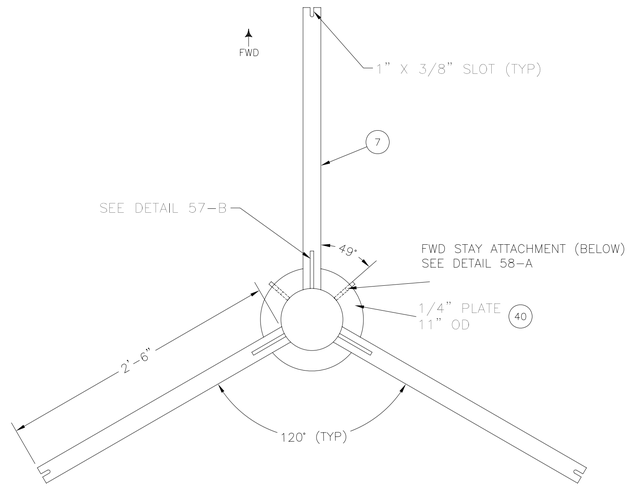


DETAIL 60-C
CROSS SECTION OF MAST BASE (LKG TO PORT)
SCALE: 3 IN = 1 FT

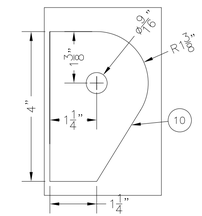
DETAIL 60-B
TYP. ATTACHMENT BRACKET (STAY TO PLATFORM)
SCALE: 3 IN = 1 FT



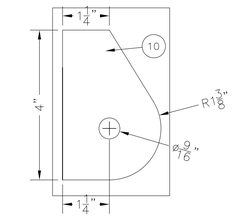
DETAIL 60-A
SPREADER ARRGT (LKG TO PORT)
SCALE: 1-1/2 IN = 1 FT



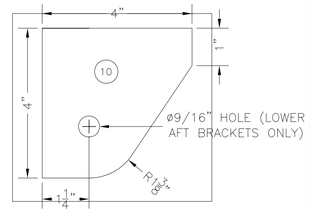
DETAIL 58-C
SPREADER ARRGT (LKG DOWN)
SCALE: 1-1/2 IN = 1 FT



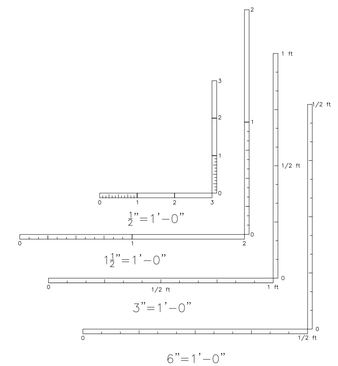
DETAIL 58-B
STAY ATTACHMENT BRACKET (BOTTOM OF MAST)
SCALE: 6 IN = 1 FT



DETAIL 58-A
STAY ATTACHMENT BRACKET
SCALE: 6 IN = 1 FT



DETAIL 57-B
TYP. SPREADER BRACKET
SCALE: 6 IN = 1 FT



RIGGING NOTES:

DIAMOND RIG TO USE FORK TERMINAL (PC #35) AT TOP OF MAST AND EYE TERMINAL (PC #36) AND TURNBUCKLE (PC #34) AT BOTTOM OF MAST.

LOWER STAYS TO USE FORK TERMINAL (PC #35) AT TOP OF MAST AND EYE TERMINAL (PC #36) AND TURNBUCKLE (PC #34) AT BOTTOM OF MAST.

PREPARED BY:
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SIZE	CAGE CODE	NOAA DRAWING NUMBER	REV
D	0YLJ5	MC-171-001	A
SCALE: AS SHOWN		CAD FILENAME MC-171-001A.dwg	SHT 8 OF 8